

# Work Order ID 66362

Friday, February 11, 2011 1:16:44 PM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *MF*

Date: 1-09-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch:

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.  
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe  
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP

11-3-10

BE 11/04/12

BE 11/04/12

BE 11/04/12

DP

11-3-14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

114

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

MA 11 04 15 (1)

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

SAD 11-04-18

(10)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SAD 11-04-18

(1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |

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Customer:

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Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

*11.05.11*

150 Skidtubes

0.00



Skidtubes Memo

0.00

✓ 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

✓ 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

✓ 3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ *116945* ☐

Sikaflex expire date: ☐ *15 Jan 2012*

Start: ☐ *11.05.12* Time: ☐ *8:00 am*

Finish: ☐ *11-05-12* Time: ☐ *1:00 pm*

(Adhere for 12 hours)

*11.05.12*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Start Date: 2/14/2011 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 2 8611/05/18

170

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DP 11-5-18

3 11/05/24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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# Work Order ID 66362

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Item ID: D206-642-541

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

4.6° 3.0"  
BEND

1 0 BE 11/05/24



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00

1 0 BE 11/05/24



Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod  
A/R ☐ Aluminum Rod ☒ M111385

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

JB

BE 11/05/26  
DL 11/05/26

11/05/25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/12/27

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/16/12/27

f20

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

X of M-11/05/30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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Qty

Reject  
Qty

Reject  
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Insp.  
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:45  
320 OF  
11:15

1X ~~Q~~ M. 11/05/30

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 ~~Q~~ M. 11/06/02

250

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/R ☐ N/A ☐ LPS-3 ☐ M109956

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R ☐ ☐ Sikaflex-291 ☐ M116945

Sikaflex expire date: ☐ 12/01

1 ~~Q~~ M. 11/06/02

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|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Set Up/  
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Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

*8 u/06/02*



270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ 1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

✓ A/R ☐ Sikaflex-291 ☐ *14116945*

Sikaflex expire date: ☐ *12/01*

✓ 3-Inspect for foreign objects as per QSI 024

✓ 4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: *N/A*

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

✓ A/R ☐ Sikaflex-291 ☐ *14116945*

Sikaflex expire date: ☐ *12/01*

*1 0 14 u/06/03*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 66362**

Friday, February 11, 2011 1:16:44 PM



Page 10

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 613

XC

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

Packaging

0.00

PPP 66369

Lup 3 @

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

CH 4/06/03  
CL 11/06/03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:16:39 PM

Page 1

Work Order ID: 66362

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
 IPP Rev:F 08-06-02 add comment DD verified by:EC  
 IPP Rev:G 08-10-09 revise details DD verified by:EC

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-1-190<br><br>Extrusion Round 3" 206   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 43.0000        | 1           | 1            |               |                |        |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>LG</div> <div>43</div> <div></div> </div> <div> <div>47575</div> <div>2</div> <div></div> </div> <div> <div>59874</div> <div>41</div> <div></div> </div>   |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| D3285-1<br><br>Cap  |                        | Manufactured  | No          |                     |                  | 110             | Each               | 114.0000       | 1           | 1            |               |                |        |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>LG</div> <div>114</div> <div></div> </div> <div> <div>52511</div> <div>66</div> <div></div> </div> <div> <div>52647</div> <div>48</div> <div></div> </div>   |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| D3282-041<br><br>Float Web (206L/407)   |                        | Manufactured  | No          |                     |                  | 150             | Each               | 4.0000         | 1           | 1            |               |                |        |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>LG</div> <div>4</div> <div></div> </div> <div> <div>65292</div> <div>1</div> <div></div> </div> <div> <div>65293</div> <div>3</div> <div></div> </div> <div> <div>66363</div> <div></div> <div></div> </div> |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

① 11-3-10  
BB 11/01/12

11.05.12

①

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:16:39 PM

Page 2

Work Order ID: 66362

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190 Each

243.0000 12 12



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

243

58545

2

60652

4

61496

2

62889

11

63359

3

65317

221



BE 11/05/24  
B68507 x12

D3275-1

Manufactured No

190 Each

53.0000 12 12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

53

53453

8

62399

1

63546

19

65295

25



BE 11/05/24  
B67767 x12

CR3212-4-03

Purchased No

250 Each

1,863.000 2 2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1863

110153

35

111359

5

112314

2

114436

448

114450

31

114859

1342



11/06/02

M 110139

x2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 11, 2011 1:16:39 PM

Page 3

Work Order ID: 66362

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No

250 Each

25.0000

1

1



Handwritten: 1117086

Nut Plate

Location

Loc Qty

Loc Code

ST056

25

33842

25

21

CCR264SS3-3

Purchased No

250 Each

154.0000

2

2



Handwritten: 1117086

Cherry Rivet

Location

Loc Qty

Loc Code

ST311

154

112314

4

113539

44

113973

106

Handwritten: 1117086

22

ALS4-1032-130

Purchased No

250 Each

1,355.000

78

78



Handwritten: 1117086

Insert

Location

Loc Qty

Loc Code

PKG11

1220

114723

220

116864

1000

ST282

96

110511

10

115911

86

ST381

39

114654

39

Handwritten: 1117331

278

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:16:40 PM

Page 4

Work Order ID: 66362

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No

270

Each

10.0000

1

1



Gasket



HL uloceloz

Location

Loc Qty

Loc Code

FP

1

B66559

xl

56055

1

FP011

8

63568

8

FP11

1

59238

1

D3536-23 Manufactured No

270

Each

11.0000

1

1



Gasket



HL uloceloz

Location

Loc Qty

Loc Code

FP011

1

63570

1

B66560

xl

ST

10

66240

10

D3536-35 Manufactured No

270

Each

16.0000

1

1



Gasket



HL uloceloz

Location

Loc Qty

Loc Code

FP012

16

58683

1

B67569

xl

63579

1

65573

2

66237

12

Friday, February 11, 2011 1:16:40 PM

Shop Packet Print

Page 4

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 66362

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-39 Manufactured No 270 Each 19.0000 1 1  
  
 Gasket  HL 11/06/02

Location Loc Qty Loc Code



FP012 18

63578 6

66241 12

FP12 1



58215 1

D3535-15 Manufactured No 270 Each 3.0000 1 1  
  
 Wearshoe  HL 11/06/02

Location Loc Qty Loc Code

FP18 3



63569 3

D3535-35 Manufactured No 270 Each 12.0000 1 1  
  
 Wearshoe  HL 11/06/02

Location Loc Qty Loc Code

FP018 12

65926 12

D3535-39 Manufactured No 270 Each 13.0000 1 1  
  
 Wearshoe  HL 11/06/02

Location Loc Qty Loc Code

FP-18 13

64076 13

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Shop Packet Print

Page 5

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:16:40 PM

Page 6

Work Order ID: 66362

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011



Required Date: 2/28/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-23 Manufactured No 270 Each 5.0000 1 1  
  
 Wearshoe  all u/06/02



Location Loc Qty Loc Code  
 FP021 5 1367594  
 63571 4

D3537-3 Manufactured No 270 Each 30.0000 1 1  
  
 Wearpad  all u/06/02

Location Loc Qty Loc Code  
 FP17 30  
 65929 30 1366230

D3537-1 Manufactured No 270 Each 39.0000 9 9  
  
 Wearpad  all u/06/02

Location Loc Qty Loc Code  
 FP017 39 1368944  
 65057 39

AN960C10L NAS1149C0332 Purchased No 270 Each 25.0000 80 80  
  
 washer  all u/06/02

Location Loc Qty Loc Code  
 ST245 25 11117291  
 107534 25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Friday, February 11, 2011 1:16:40 PM

Page 7

Work Order ID: 66362

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C416 NAS1149C0463 Purchased No

270 Each

29.0000 1 1



washer



all 1/10/02

Location

Loc Qty

Loc Code

ST346

29

M117735

X1

100993

29

D3672-1 Manufactured No

270 Each

1,149.000 2 2



Phenolic Washer



all 1/10/02

Location

Loc Qty

Loc Code

ST077

1149

42329

10

52505

139

64177

1000

XZ

AN3C4A Purchased No

270 Each

1,420.000 80 80



BOLT



all 1/10/02

Location

Loc Qty

Loc Code

ST350

1420

M117091

X80

115300

25

116075

361

116590

34

116704

1000

AN4C5A Purchased No

270 Each

439.0000 1 1



BOLT



all 1/10/02

Location

Loc Qty

Loc Code

ST346

439

110552

1

112243

438

X1

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Shop Packet Print

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, February 11, 2011 1:16:40 PM

Page 8

Work Order ID: 66362

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

76.0000

1

1



Aft Cap



110602

Location

Loc Qty

Loc Code

FP-4

6

57332

6

FP6

16

52663

3

62678

12

63633

1

Return 2010

54

62678

54

X1

D3413-1

Manufactured No

270

Each

25.0000

1

1



Ring



Location

Loc Qty

Loc Code

ST420

9

62961

9

ST473

16

51586

1

53446

5

65294

10

66945

X1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

RELEASED

07.02.12

DEO ATTACHED

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><b>CP</b>           | DRAWN BY<br><b>PH</b>          | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA |                        |
| CHECKED<br><b>[Signature]</b> | APPROVED<br><b>[Signature]</b> | DRAWING NO.<br><b>D3274</b>                         | REV. D<br>SHEET 1 OF 4 |
| DATE<br><b>06.12.19</b>       |                                | TITLE<br><b>SKIDTUBE ASSEMBLY</b><br>SCALE<br>NTS   |                        |
| A                             | 04.03.15                       | NEW ISSUE   |                        |
| B                             | 04.08.09                       | MOVE SADDLE HOLE: 42.14 WAS 42.76                   |                        |
| C                             | 05.03.16                       | ADD -043; NEW INSERTS                               |                        |
| D                             | 06.12.19                       | NEW INSERTS, SS WEARSHOE + GASKET                   |                        |

| Qty<br>-041 | Qty<br>-043 | Part Number   | Description   |
|-------------|-------------|---------------|---|
| X           |             | D3274-041     | SKIDTUBE ASSEMBLY                                       |
|             | X           | D3274-043     | SKIDTUBE ASSEMBLY                                       |
| 1           | 1           | D2600-1-240   | EXTRUSION   |
| 1           | 1           | D2646         | AFT CAP   |
| 12          | 12          | D2649         | CROSS BOLT SPACER                                       |
| 12          | 37          | D3275-1       | CROSS BOLT SPACER                                       |
| 1           | 1           | D3282-041     | FLOAT WEB   |
| 1           | 1           | D3285-1       | CAP   |
| 1           | 1           | D3413-1       | RING  |
| 1           | 1           | D3415-041     | NUT PLATE   |
| 1           | 1           | D3535-15      | WEARSHOE  |
| 1           | 1           | D3535-23      | WEARSHOE  |
| 1           | 1           | D3535-35      | WEARSHOE  |
| 1           | 1           | D3535-39      | WEARSHOE  |
| 1           | 1           | D3536-15      | GASKET  |
| 1           | 1           | D3536-23      | GASKET  |
| 1           | 1           | D3536-35      | GASKET  |
| 1           | 1           | D3536-39      | GASKET  |
| 9           | 9           | D3537-1       | WEARPAD   |
| 1           | 1           | D3537-3       | WEARPAD   |
| 78          | 78          | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80          | 80          | AN3C4A        | BOLT  |
| 1           | 1           | AN4C5A        | BOLT  |
| 1           | 1           | AN960C416     | WASHER  |
| 80          | 80          | AN960C10L     | WASHER  |
| 2           | 2           | CCR264SS3-3   | RIVET   |
| 2           | 2           | CR3212-4-03   | RIVET   |
| 2           | 2           | NAS1515H3L    | WASHER  |

**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

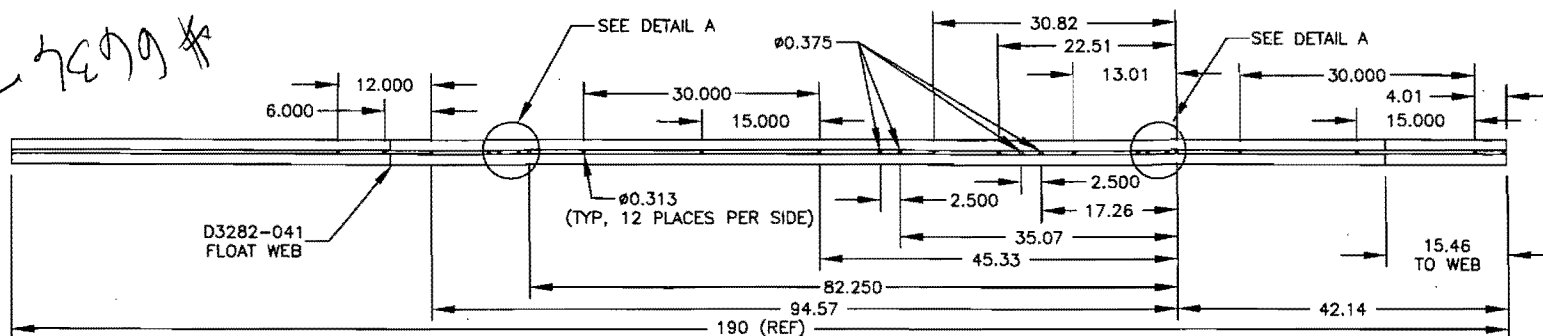
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

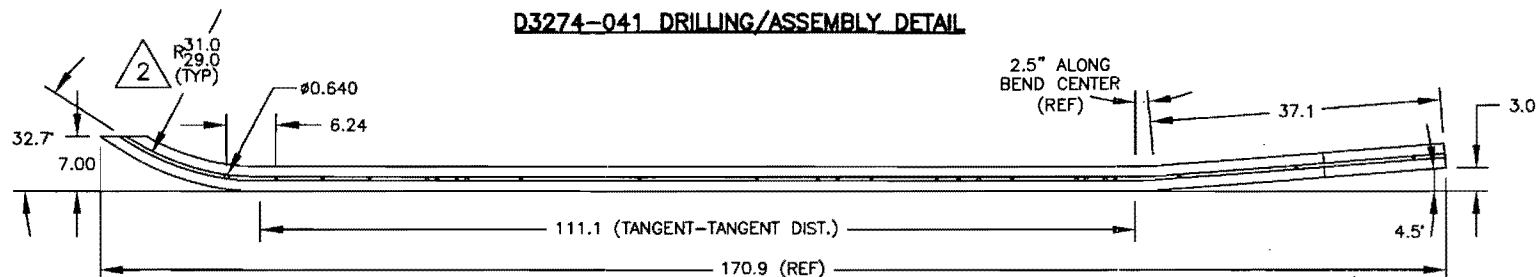
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

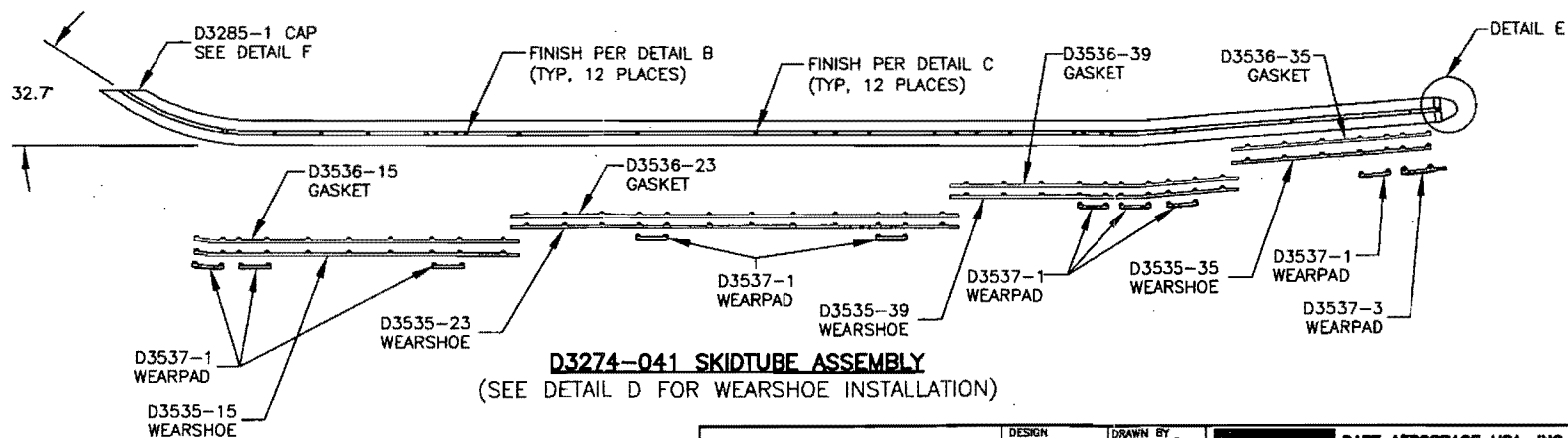
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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| DESIGN  | CP       | DRAWN BY | PH                | <b>DART</b> DART AEROSPACE USA, INC.<br>PORT WILKINSON, WA |
| CHECKED | #        | APPROVED | #                 | DRAWING NO.<br>D3274                                       |
| DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | REV. D<br>SHEET 2 OF 4<br>SCALE<br>1:15                    |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

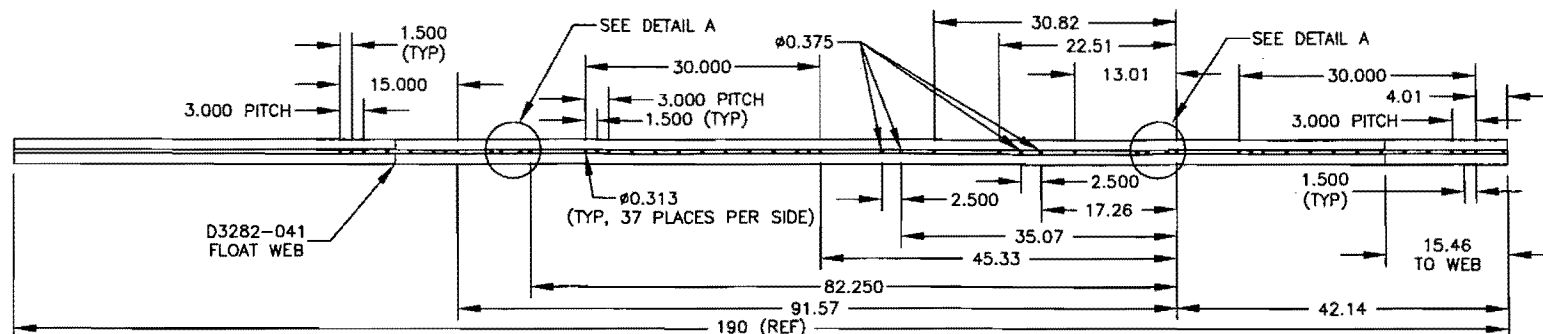
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

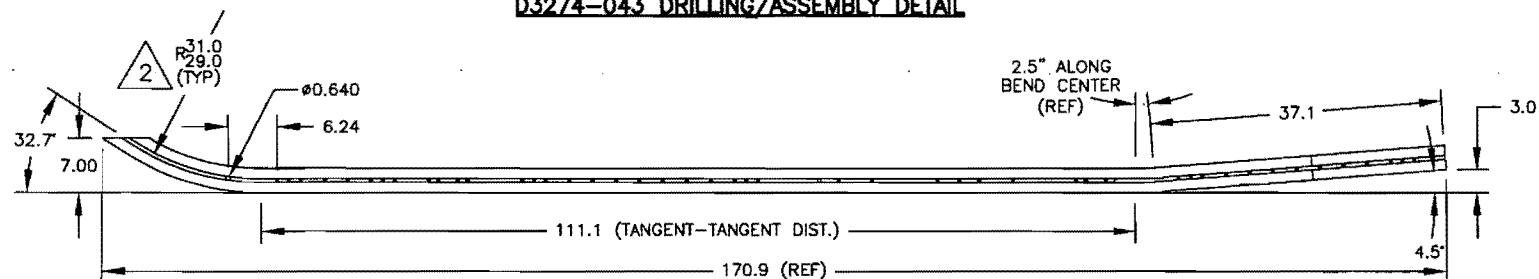
**NOTE:** Date & initial all entries



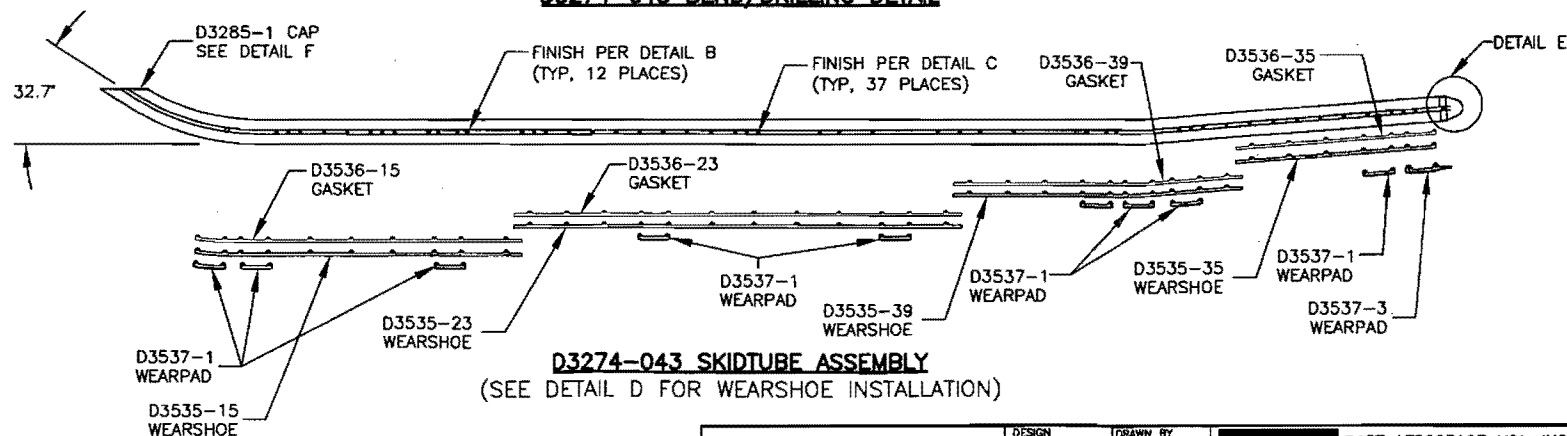
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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|---------|----------|----------|-------------------|-------------|--------------------------|
| DESIGN  | CP       | DRAWN BY | PH                | <b>DART</b> | DART AEROSPACE USA, INC. |
| CHECKED | #        | APPROVED | #                 | DRAWING NO. | D3274                    |
| DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | REV. D      | SHEET 3 OF 4             |
|         |          |          |                   | SCALE       | 1:15                     |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

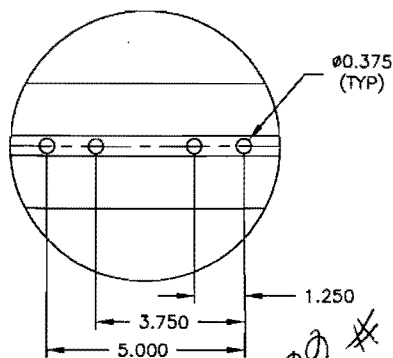
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

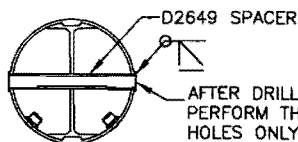
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# **DETAIL A: DRILL DETAIL**

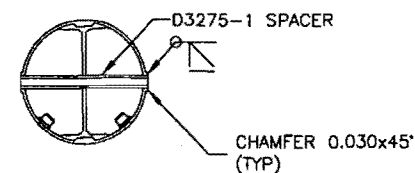


# **DETAIL B** FOR 0.375 HOLES ONLY

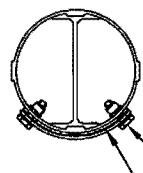


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# **DETAIL C** FOR 0.313 HOLES ONLY



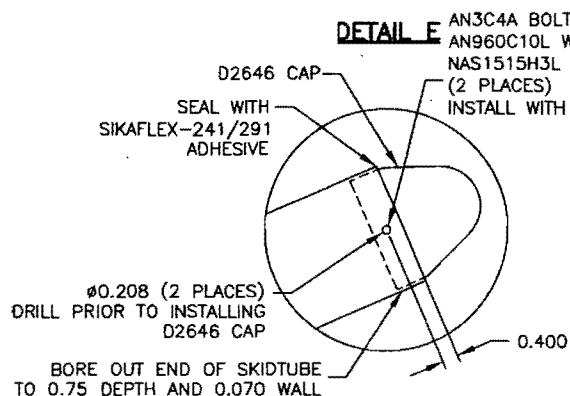
# **DETAIL D**



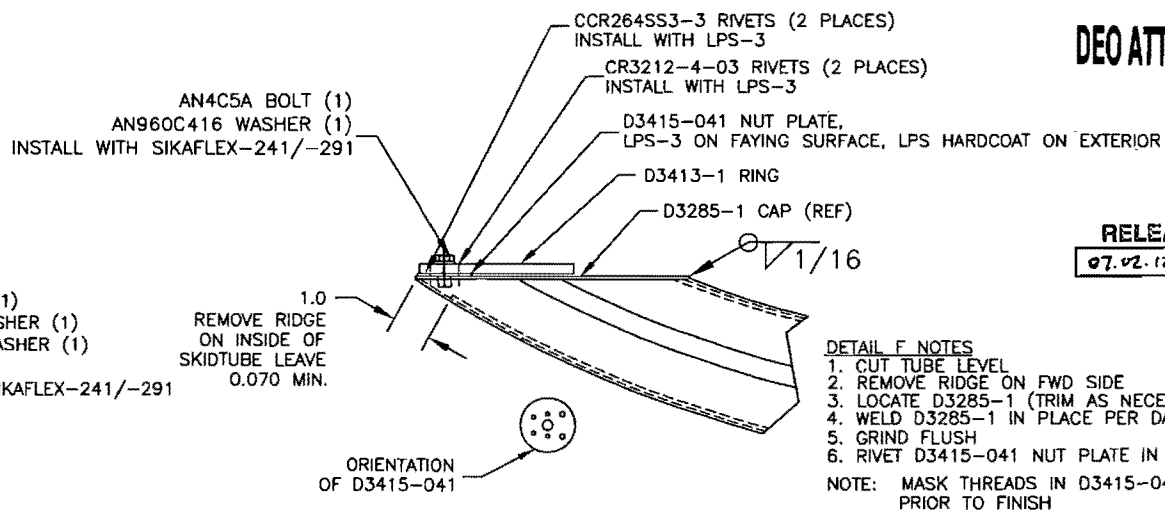
- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

# **DETAIL E**



# **DETAIL F: END FINISHING DETAIL**



**DEO ATTACHED**

**RELEASED**

07.02.12 #

# **DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

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|---------|----------|----------|-------------------|--|
| DESIGN  | CP       | DRAWN BY | PH                | <b>DART</b> DART AEROSPACE USA, INC.<br>PORT HADLOCK, MA |
| CHECKED | #        | APPROVED | #                 | DRAWING NO.<br>D3274                                     |
| DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | REV. D<br>SHEET 4 OF 4<br>SCALE<br>1:3                   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                      |                            |                               |                                |                             |                           |              |
|----------------------|----------------------------|-------------------------------|--------------------------------|-----------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3274 | TITLE<br>SKIDTUBE ASSEMBLY | REV. D                        | <b>DART AEROSPACE USA, INC</b> | D.E.O. NO.<br>D3274-D-1     | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN <i>UP</i>      | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i>    | DE APPR. <i>[Signature]</i> |                           |              |
| DATE 09.06.17        | DATE 09.06.23              | DATE 09/06/23                 | DATE 09/06/23                  | DATE 09.06.23               |                           |              |

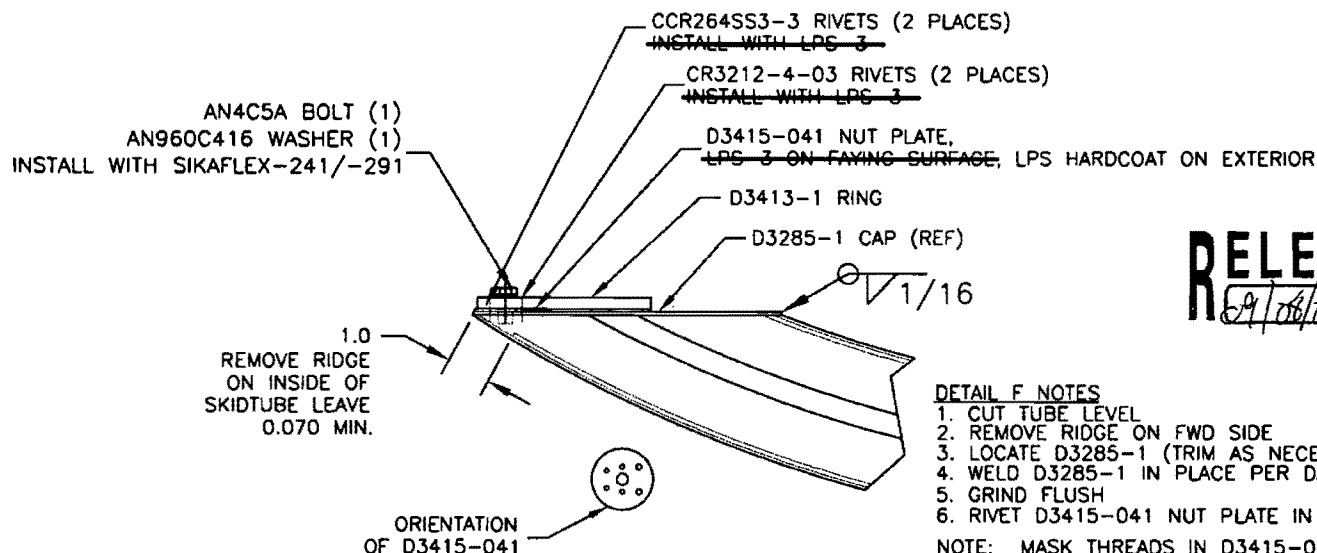
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

*09/06/23*

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

NO. 252

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 66358  
Part number: 5206 642 541  
Description: 206  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Burns Date of Test Coupon 11-05-09

Welder Barclay Elliott Date of Test Coupon 11-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

